

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022061**Date Inspected:** 20-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. An Qing xiang / Mr. Liu hua jie			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder(OBG)	

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly open yard.

Segment: 12AE

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3007K-026. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2113-FCM-1.

SMAW welding of weld joint identified as SEG3007ADA-032. Welder is identified as 037743. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3007G-010. Welder is identified as 050242. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed

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appeared to comply with WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint identified as SEG3007G-011. Welder is identified as 050242. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC personnel connecting the OBG segment identified as 13AW to the segment 12CW. See attached photos for further details.

OBG Assembly bay#14

Segment: 13BW

SMAW welding of weld joint identified as SEG3014-006. The welders are identified as 067572, 067764 and 066443. ZPMC QC is identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Segment: 13CW

FCAW welding of weld joint identified as SA3232B-004. The welder is identified as 048696. ZPMC QC is identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer